

Date: Monday, 5/15/2006 10:44:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 27091		
Estimate Number	: 10584		
P.O. Number	: N/A	Part Number	: D1048
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D1048 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 27076	Material	: N/A
Written By	: SEE A COMMENT BELOW	Due Date	: 5/30/2006
Checked & Approved By	: 06.05.15	Qty:	50 Um: Each
Comment	: Est: B 02.22 Re-format NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1263

Stamp and deburr per dwg D1048

Material: Stainless steel T304#2B Supply release not for Material.

C 206105/16 (50)

laser cut flat pattern

2.0	D1048F	Clamp
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Comment: Qty.: 1.0000 U(s)/Unit Total : 50.0000 U(s)
 CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

10/15/25

(50)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.05.29 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

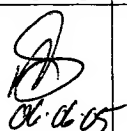


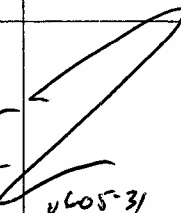
2-Form as per dwg D2010 using DT8053

SAD 0006701

06:06:01

47 (P/O)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-05-31	5	3 Parts were not formed properly. Placed wrong in band sig. Band not centered in the part.	 06-06-05	SCVMP: destroy.	SAD 06-06-05 05-31	 06-05-31	 06-06-05 05-31	 06-05-31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 10:44:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 27091

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ep 06/05/01 x 47

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

pl 06/06/01

(47)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STOP

pl 06/06/01 (47)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

pl 06/06/02

(47)

Job Completion



W 06/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

RELEASED
97/09/02 BCL

NOTES:

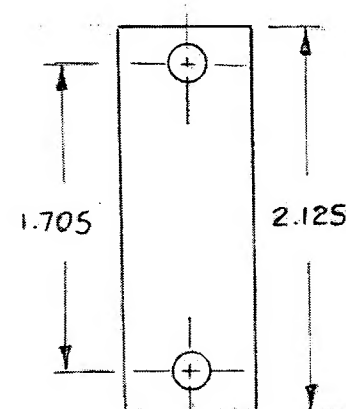
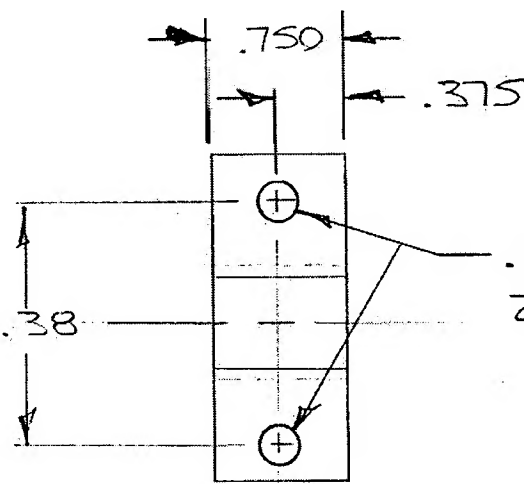
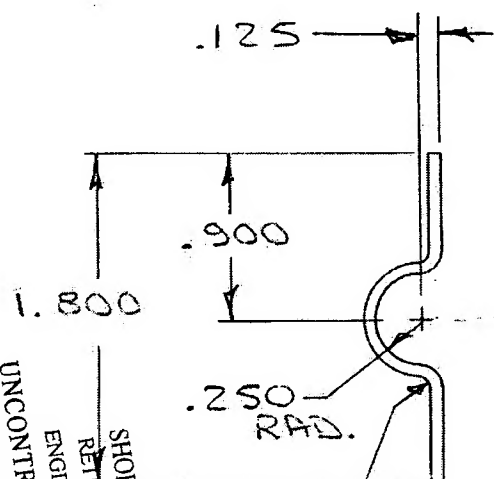
1) MATERIAL

STAINLESS STEEL

T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



FLAT PATTERN

NO. 27091
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



A		REVISION	RIVET CODE SHALL BE PER NAS 623		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENOOR
RF		DRAWN	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMOD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
1		APPROVED	BASIC CODE		DRAWN BRADLEY		DATE 5/1/97		TITLE CLAMP
1.1.2.05		DESCRIPTION OF CHANGE	D-DIMPLE D-DIMPLE NO. OF SHEETS C-COUNTERSINK		DESIGN BRADLEY		STRESS		
1.1.2.05			BASIC CODES		CHECKED		CODE		
1.1.2.05			BASIC CODES		CLIENT		DWG NO. D1048		
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED			LIMITS		LENGTH DASH NO. W-SPOTWELD		SCALE 1:1		SHT 1 OF 1
GENERAL			LIMITS		BASIC CODES		REV A		
1. DIMENSIONS ARE IN INCHES			1. TOLERANCES — .005 & .030		8P-M52047040				
2. SURFACE ROUGHNESS 125			2. ANGLES .005 & .010		8B-M52042540				
3. REMOVE SHARP EDGES .015 MAX			3. PARALLELISM .0025						
4. THREADS PER INCH — 5 — 7742			4. ECCENTRICITY .005 MAX						
5. HOLES PER AND 10307			5. SYMMETRY ABOUT ALL M.C. CENTRE LINES .005						
REPORT ALL DISCREPANCIES — DO NOT SCALE									

D1048



CAMBRIDGE STEEL MILL
160 ORION PLACE
CAMBRIDGE ON N1R 1R9 CAN
(519) 740-2488

Chemical and Physical Test Report

MADE IN CANADA

N-037186

SHIP TO VEDDER TRANSPORT C/O WILKINSON STEEL AND METALS 586 RIVERSIDE ROAD ABBOTSFORD, BC	INVOICE TO WILKINSON STEEL & METALS VAN PREMETALCO INC 888 SOUTHEAST MARINE DR. VANCOUVER, BC V5X 2V3	SHIP DATE 01/12/06 CUST. ACCOUNT NO 69073699
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SHAPE + SIZE																	GRADE		SPECIFICATION																	SALES ORDER		CUST P.O. NUMBER																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																		
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Mechanical Test: Yield 50258 PSI, 346.52 MPA Tensile 74435 PSI, 513.21 MPA %El: 27.0/in, 27.0/200MM Red R 26.7 : 1
Mechanical Test: Yield 49665 PSI, 342.43 MPA Tensile 74737 PSI, 515.29 MPA %El: 27.0/in, 27.0/200MM Red R 26.7 : 1

Mechanical Test																	YIELD 49500 PSI, 342.43 MPa TENSILE 74737 PSI, 515.23 MPa ELOC 27.000%, 27.000																
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Mechanical Test: Yield 48109 PSI, 331.7 MPA Tensile 70847 PSI, 488.47 MPA %El: 28.5/in, 28.5/200MM Red R 26.7 : 1
Mechanical Test: Yield 48088 PSI, 331.65 MPA Tensile 71075 PSI, 490.04 MPA %El: 28.0/in, 28.0/200MM Red R 26.7 : 1

MECHANICAL TEST		TENSILE 41KR20 P31, 331.50 MPa		TENSILE 71KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 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MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa		TENSILE 20KR20 P31, 331.50 MPa		TENSILE 20KR75 P31, 400.04 MPa	
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Mechanical Test: Yield 50567 PSI, 348.65 MPA Tensile 73436 PSI, 506.32 MPA %El: 27.0/in, 27.0/200MM Red R 26.7 : 1
Mechanical Test: Yield 50554 PSI, 348.56 MPA Tensile 73611 PSI, 507.53 MPA %El: 27.0/in, 27.0/200MM Red R 26.7 : 1

This material, including the billets, was produced and manufactured in Canada.

A.J. Turner
Quality Assurance Manager
Mill Group

THE ABOVE FIGURES ARE CERTIFIED EXTRACTS FROM THE ORIGINAL CHEMICAL AND PHYSICAL TEST RECORDS
AS CONTAINED IN THE PERMANENT RECORDS OF COMPANY.

John H. Hanch

Mgr. Metallurgy Svc.
CAMBRIDGE STEEL MILL

P51013PC002

MILL TEST CERTIFICATE

872

ORIGINAL

YIEH MAU CORP.

YIEH MAU CORP.

INVOICE NO. : F03MA29

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION : AISI 304

CUSTOMER : OLBERT METAL SALES LIMITED

工廠:高雄縣北梓鄉廣安路345號
345, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)8812885 FAX:(07)8918006
CERTIFICATE NO: F03MA29
DATE OF ISSUE: 11/30/2005

PO 1263 16GA 304 SS.

SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL-50 as/is					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304/NO.4 (FILM ON MAIN SIDE WITH BACK PASS)																		
16GA / 48" X 96"	1	1,476	3,254	YU296038	4AS16493A-32	297	659	51	79	149	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 96"	1	1,479	3,261	YU234718	4AS16505B-21	310	690	59	81	158	4.1	55	124	31	7	804	1816	3.1
16GA / 48" X 96"	1	1,479	3,261	YU234718	4AS16505B-22	316	690	59	81	158	4.1	55	124	31	7	804	1816	3.1
16GA / 48" X 120"	1	1,530	3,373	YU210059	4AS16494A-11	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,535	3,384	YU236038	4AS16494A-12	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,539	3,391	YU236038	4AS16494A-13	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,540	3,395	YU236038	4AS16494A-14	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,541	3,397	YU236038	4AS16494A-15	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	797	1,603	YU236038	4AS16494A-16	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,533	3,380	YU234718	4AS16505B-23	316	690	59	81	158	4.1	55	124	31	7	804	1816	3.1
16GA / 48" X 144"	1	1,388	2,990	YU236038	4AS16493A-31	297	659	51	79	149	4.3	48	105	32	12	805	1818	2.9
12GA / 48" X COIL	1	3,308	7,293	YU139569	4BS18207A-11	310	626	52	83	163	4.5	46	127	31	7	816	1817	2.6
TOTAL: 12 19,024 41,942																		
Remarks: NO MERCURY CONTAMINATION Heat test: good for all Heat NO.																		

YIEH MAU CORP.

Lin Kun Hsing
Manager of Quality Assurance Center

06-05-29

P.03

505 755 1320

OLBERT METAL SALES

JAN-10-2006 15:59

PROCESSOR: I T M INDUSTRIAL (P51013PC002.YU236038)